

# Work Order ID 51155

September 1, 2009 10:12:58 AM



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Item ID: D3685-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/24/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 09/04/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-09-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3685	Rev C								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-Use anti-seize compound Tectly 502c Class 1,Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3685 □2-Assemble D3684-047 & D3687-3 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3685□***Ensure holes for AN3C Bolts are free sealant								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

09/09/01

09/09/01

09/09/01

2 7

2 7

2 7

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Item ID:	D3685-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	BIPOD MOUNT ASSEMBLY					
Start Date:	08/24/2009	Start Qty:	2.00			
Required Date:	09/04/2009	Req'd Qty:	2.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <i>139C</i>	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*9/9/11* *(2x) SD*

*09/09/02* *MF* *09-09-02*

# Picklist Print

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Work Order ID: 51155

Parent Item: D3685-041RevC

Parent Item Name: BIPOD MOUNT ASSEMBLY


Start Date: 08/24/2009

Required Date: 09/04/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C12A		Purchased	No			110	Each	447.0000	8.0000			
												
Bolts												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	447	
106993	7	
110155	2	
110552	3	
110584	17	
111916	20	
112314	398	

D3684-047RevC

Manufactured

No

110

Each

1.0000

2.0000



FWD LEG ASS'Y

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	1	
45600	1	

D3684-049RevC

Manufactured

No

110

Each

1.0000

2.0000



AFT LEG ASS'Y

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	1	
45601	1	

B 51148

8 09/09/01 (2)

(2) 8 09/09/01 (2)

(2) 8 09/09/01 (2)

# Picklist Print

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Work Order ID: 51155



Parent Item: D3685-041RevC



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/24/2009

Required Date: 09/04/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3687-3RevB		Manufactured	No			110	Each	11.0000	2.0000			
MOUNT												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    11

45912    2

46761    9

D3692-1RevB

Manufactured      No

110

Each

736.0000

16.0000



SPACER

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    59

44827    8

45672    14

50325    37

Main Warehouse

ST127    677

50736    269

51467    408

88 09/09/01 ②  
2

88 09/09/01 ②  
16

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Shop Packet Print

# Picklist Print

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Work Order ID: 51155



Parent Item: D3685-041RevC



Parent Item Name: BIPOD MOUNT ASSEMBLY

Start Date: 08/24/2009

Required Date: 09/04/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			110	Each	5,342.000	8.0000			

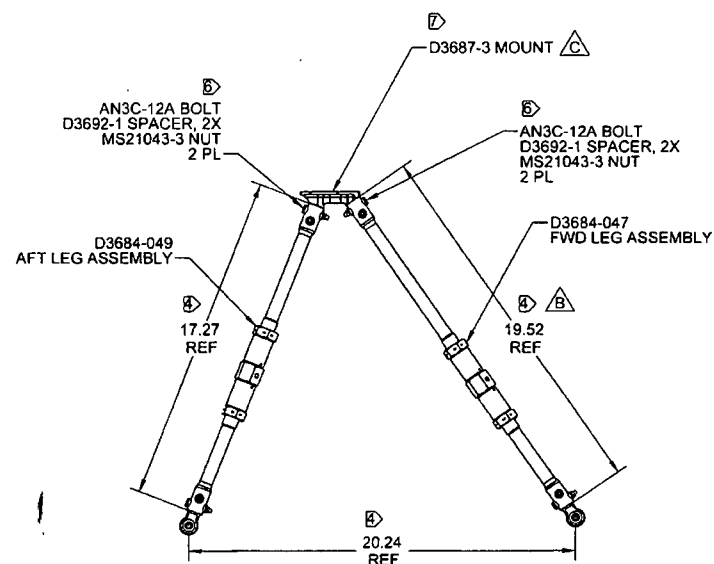
Nut

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	80	
103691	80	
Main Warehouse		
ST	5262	
111819	76	
112243	210	
112314	4976	

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AS 09/09/01 (2)

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3685-041	BIPOD MOUNT ASSEMBLY
2	1	D3687-3	MOUNT
3	1	D3684-047	FWD LEG ASSEMBLY
4	1	D3684-049	AFT LEG ASSEMBLY
5	8	D3692-1	SPACER
6	4	AN3C-12A	BOLT
7	4	MS21043-3	NUT



**D3685-041 BIPOD MOUNT ASSEMBLY**

**NOTES:**

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3685-041 USING FINE POINT PERMANENT INK MARKER
- 4) DIMENSIONS SHOWN ARE WHEN D3688-1/3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVES
- 5) WEIGHT: 6.6 lbs
- 6) TORQUE FASTENERS TO 20-25 in-lbs
- 7) ASSEMBLE D3684-047 & D3684-049 WITH D3687-3 USING SIKAFLEX-241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

**RELEASED**  
09/01/12 MB

C	NOW ASSEMBLED USING SEALANT (ZN A8-1, C4-1)	RF	08.12.15
B	19.52 WAS 19.95 (ZN 84-1); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D3685	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BIPOD MOUNT ASSEMBLY	NTS
DATE	08.12.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries